










Date: Friday, 26/09/2008 9:14:26 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 42159		
Estimate Number	: 10265		
P.O. Number	:	Part Number	: D350636012
This Issue	: 26/09/2008 S.O. No. :	Drawing Number	: D2750 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SKIDTUBES	Drawing Revision	: F
Previous Run	: 42158	Material	:
Written By	: <u>JD 08.9.26</u>	Due Date	: 03/10/2008 Qty: 1 Um: Each
Checked & Approved By			
Comment	: Est Rev: I 02.09.25 Rearranged procedure steps KJ Est Rev: J 06-03-29 As per Rev D EC Est Rev: K 06-07.13 As per dsi9343 EC Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC Est Rev: N 08-09-23 revF as per dwg DD verified by: ec		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy blue file and type labels per PPP D350-636-012 CHG 004 <u>JD 08.10.01</u> <u>08/10/07</u>			
2.0	D26003BENT	Extrusion Bent	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-3-Bent Extrusion (Bent) <u>24122 BE 08/09/26</u>			
3.0	D2744	Cap	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Cap Batch: <u>23242 BE 08/09/26</u>			
4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1 1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end 2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

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Job Number:



Seq. #:

Machine Or Operation:

Description:

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube*****

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI-004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod

10-Grind welds flush as per Dwg D2750

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/09/30 (P)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/30 (P)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BT 08-09-30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PZ 08/09/30 (P)

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B42264 D M 8-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-012 PAR #: N/A Fault Category: Prod / Skid tube NCR: Yes No DQA: D Date: 08/10/22

Resolution: _____ Disposition: _____ QA: N/C Closed: Ag Date: 08/10/22

NCR: <u>42159</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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<u>6/9/29</u>	<u>4.4</u>	employee Drilled pilot holes for left hand and realized it was ^{it was} for right hand	<u>Possum</u>	Fill both holes with weld as per Q57004 A/K/M/08708 - ensure inside of tube is smooth	<u>BE</u> <u>08/09/29</u>	<u>08/09/30</u>	<u>Possum</u>	<u>6/9/29</u>
		R.C. Hammer error Lack of Attention	<u>Possum</u>	Grind welds flush.	<u>BE</u> <u>08/09/29</u>	<u>08/09/30</u>	<u>Possum</u>	<u>6/9/29</u>

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Job Number: 42159

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *439584*

BE 08/10/01

11.0	D34903	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *441136*

BE 08/10/01

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: *440725*

BE 08/10/01

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

exp. date:

mp9388
8-11-1

U 8-9-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

IT
08-09
-30

W/O:		WORK ORDER CHANGES					
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Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R

Aluminum Rod

batch: M109213 SE 08/10/01

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

-AWM
8-10-02

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/10/03 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/03 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-1 08/10/06

17.0

POWDER COATING

POWDER COATING



M109152



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50
320°C
1:20

M-1 08/10/06

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-10-07 (X1)

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: M100621

M2 08-10-07 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42159

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Install inserts as per dwg D2750

HL 08-10-07 (X)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch: B41114

HL

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B412418

HL

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B40551

HL

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B40552

HL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B40553

HL

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B339713

HL

08-10-07 (X)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42159

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1341633

JA

28.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 13410729

JA

29.0	D35371	Wearpad
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 13411082

JA

30.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 1341141

JA

31.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: 1338787

JA

32.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: (5x) => 41137

1342182 (x3)

JA

33.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1341138

JA

DE-40-07 (x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42159

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M108928

Handwritten initials

35.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108880

Handwritten initials

36.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M109091

Handwritten initials

37.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896

Handwritten initials

38.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M108928

Handwritten initials

39.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M1108928

Handwritten initials

40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M1108857

Handwritten initials

08-10-07

Handwritten circled mark

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Seq. #:	Machine Or Operation:	Description :
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41.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M109485

JA

42.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M1108964

JA

43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: M1107912

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

✓ BATCH: M109338

EXP DATE: 08/11

4-Coat all exposed fasteners with "LPS Procyon"

✓ batch: M1104251

JA 08-10-07 (X1)

44.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/10/16 @

45.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

46.0	D2741	Blade, 350 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 40729

✓ 5/10/12 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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47.0	AN960C816L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M109632

48.0	MS21083C8	NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: 109040

49.0	AN8C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M109092

50.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: 108964

51.0	D34931	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: 108964 40829

52.0	D35321	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
spacer
Batch: 40829 41846

53.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08/10/17 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Description :

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev G

AS-08/10/17

55.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-20

B42159

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

NO. 175

(352)

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41860
Part number: D350 636011
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Duval Date of Test Coupon 08-08-26
Welder Barclay Elliott Date of Test Coupon 08-09-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA	DART AEROSPACE USA, INC.	
DRAWN		DRAWING NO. REV. F	
CHECKED		D2750 SHEET 1 OF 11	
MFG. APPR.		TITLE SCALE	
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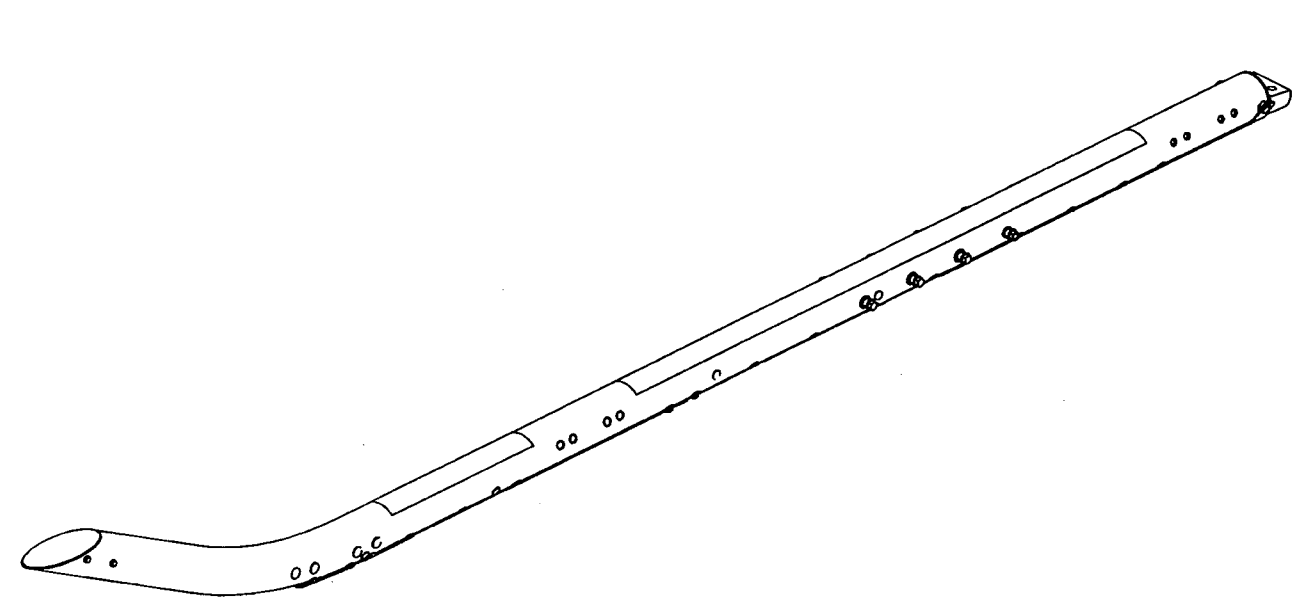
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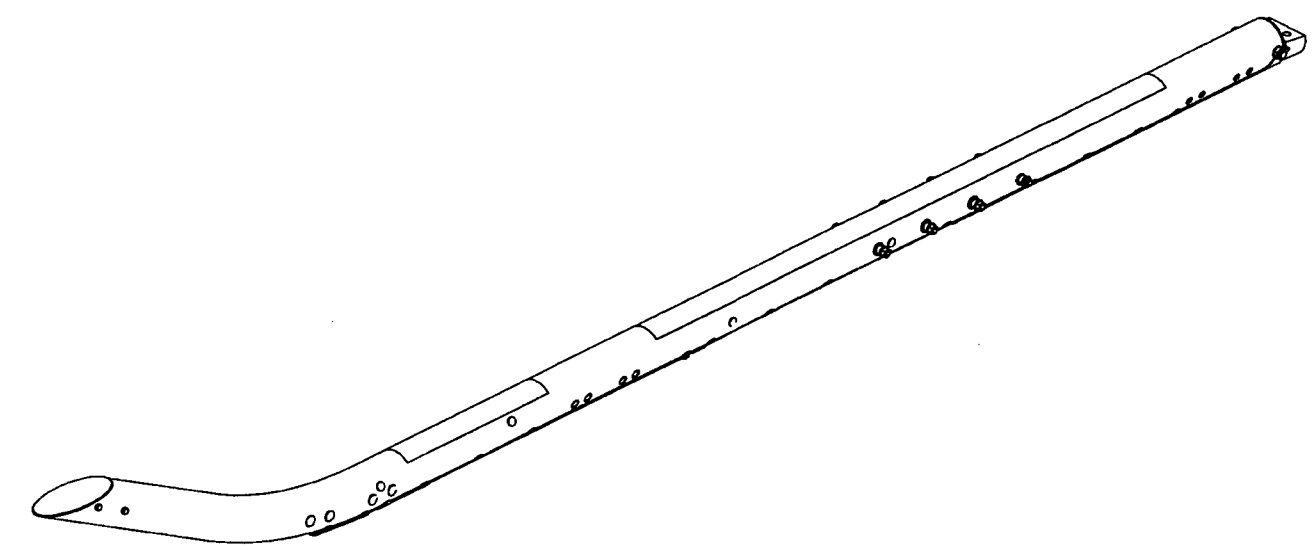
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B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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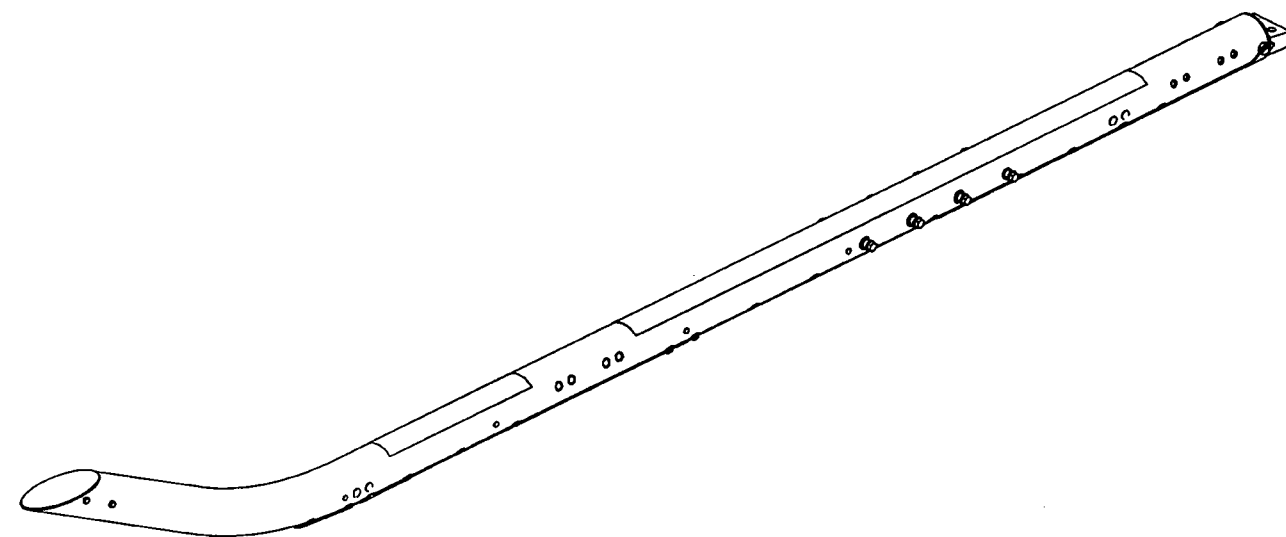
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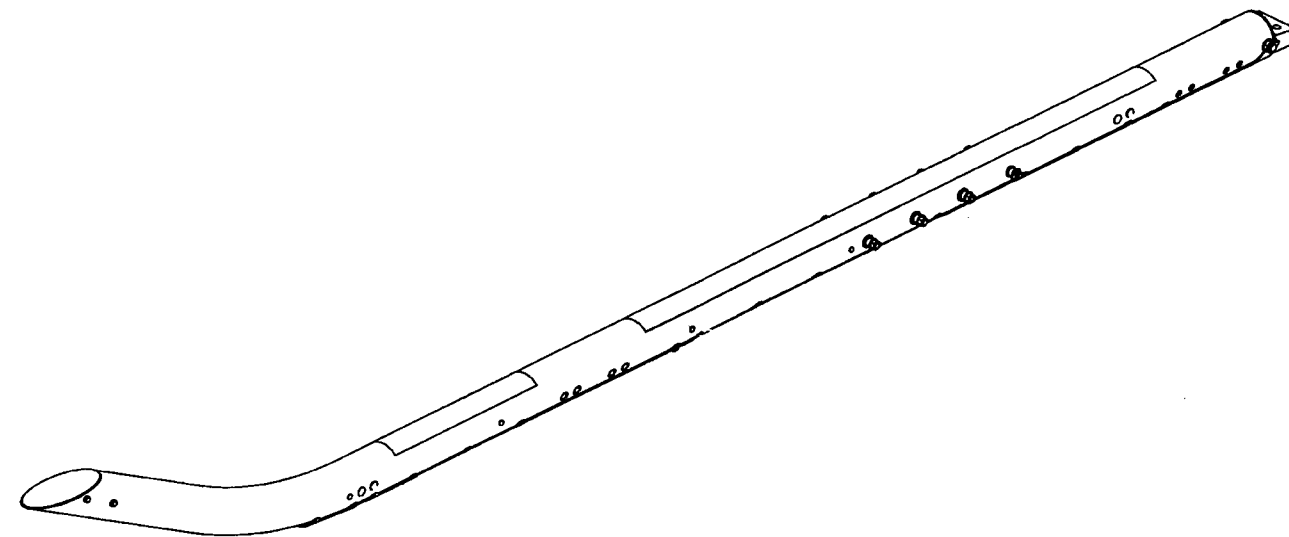
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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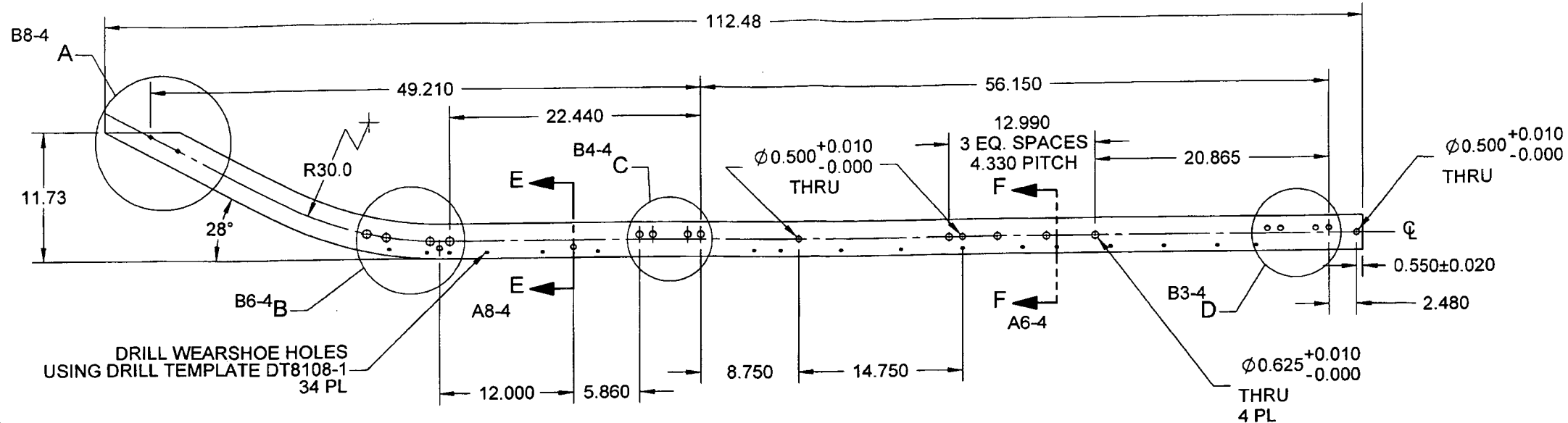
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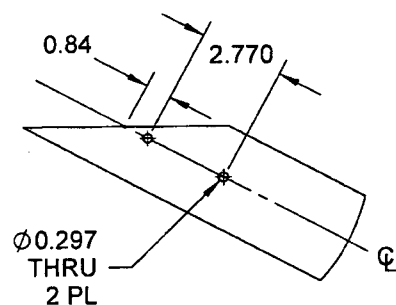
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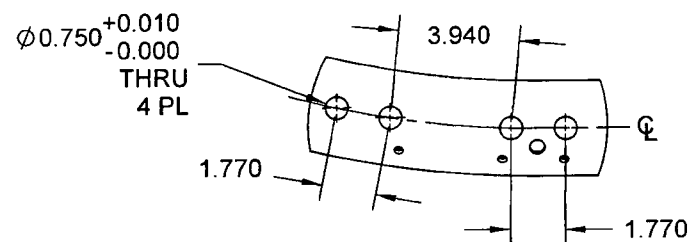
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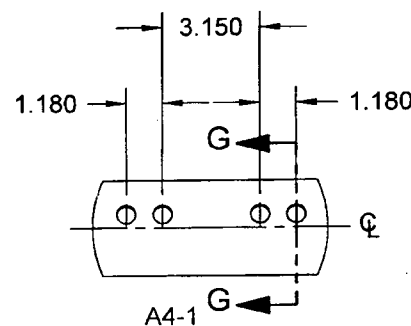
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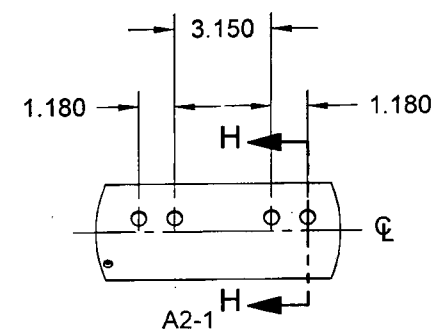
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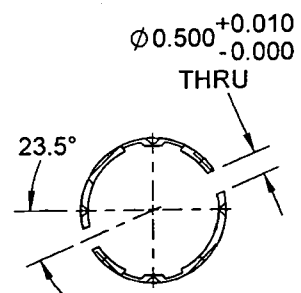
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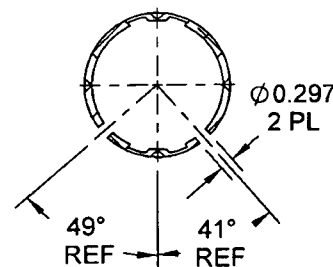
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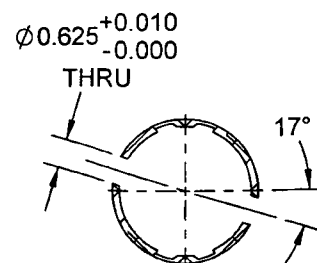
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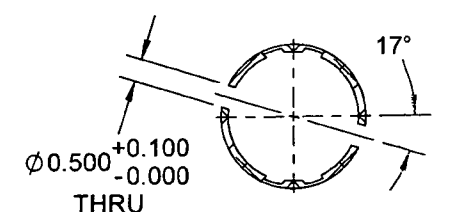
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

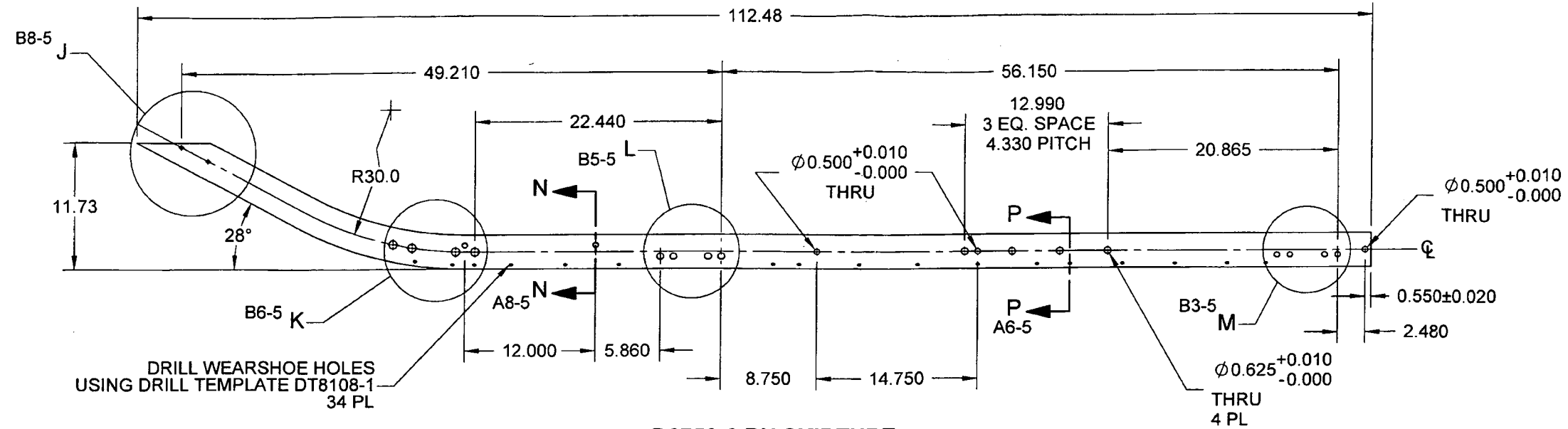


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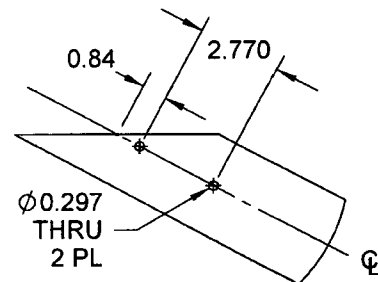
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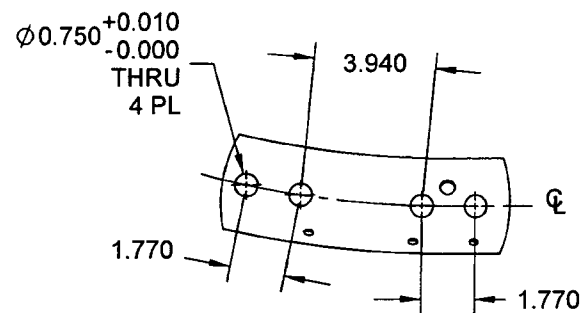
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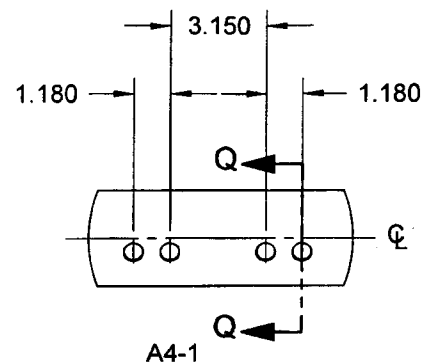
D2750-2 RH SKIDTUBE



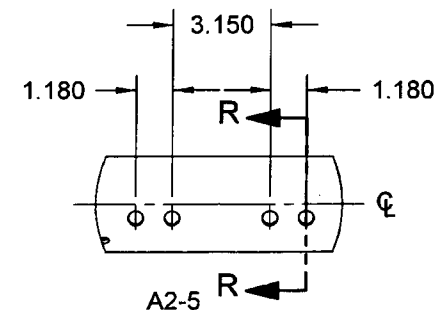
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D8-5



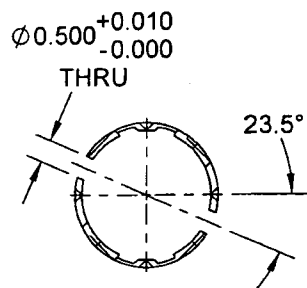
DETAIL K
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C7-5



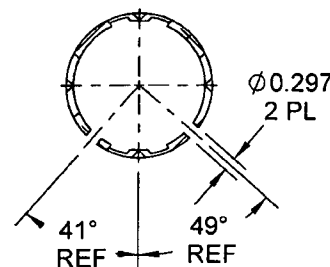
DETAIL L
SCALE 2X
D6-5



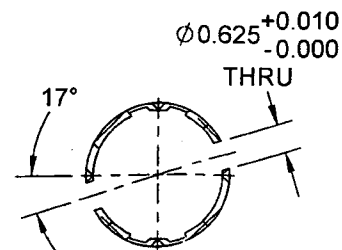
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SCALE 2X
C3-5



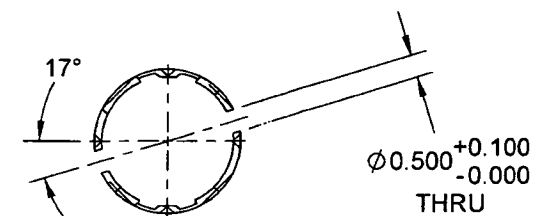
SECTION N-N
SCALE 3X, 2 PL
C6-5



SECTION P-P
SCALE 3X, 17 PL
C4-5



SECTION Q-Q
SCALE 3X, 4 PL
B5-5



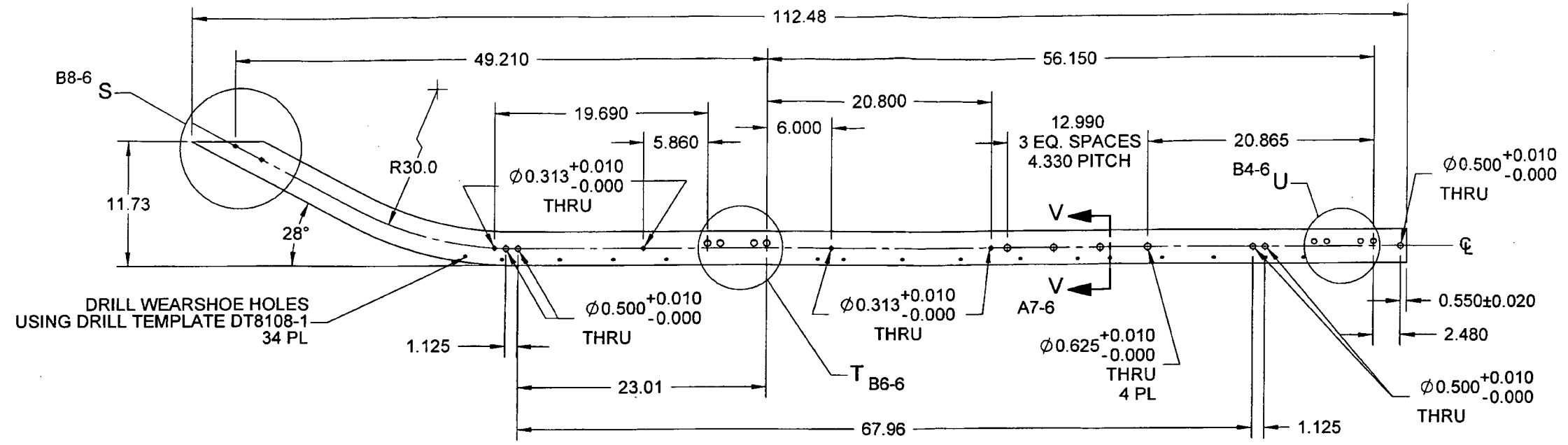
SECTION R-R
SCALE 3X, 4 PL
B3-5

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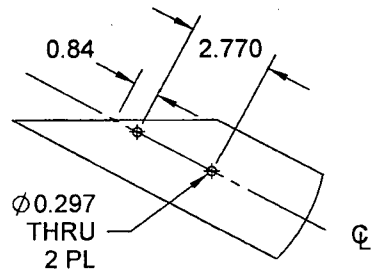
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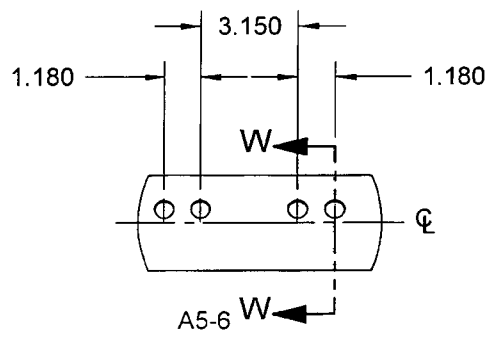
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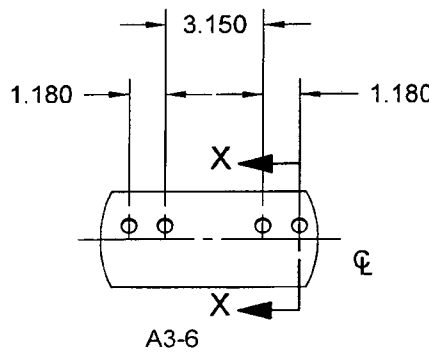
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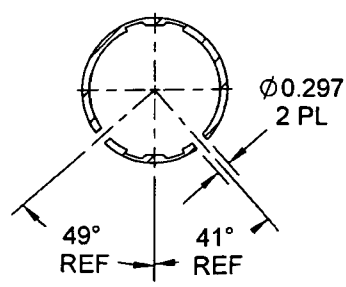
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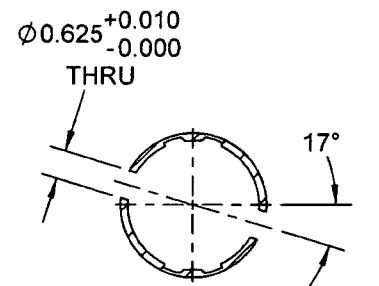
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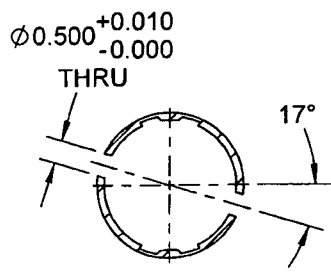
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SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

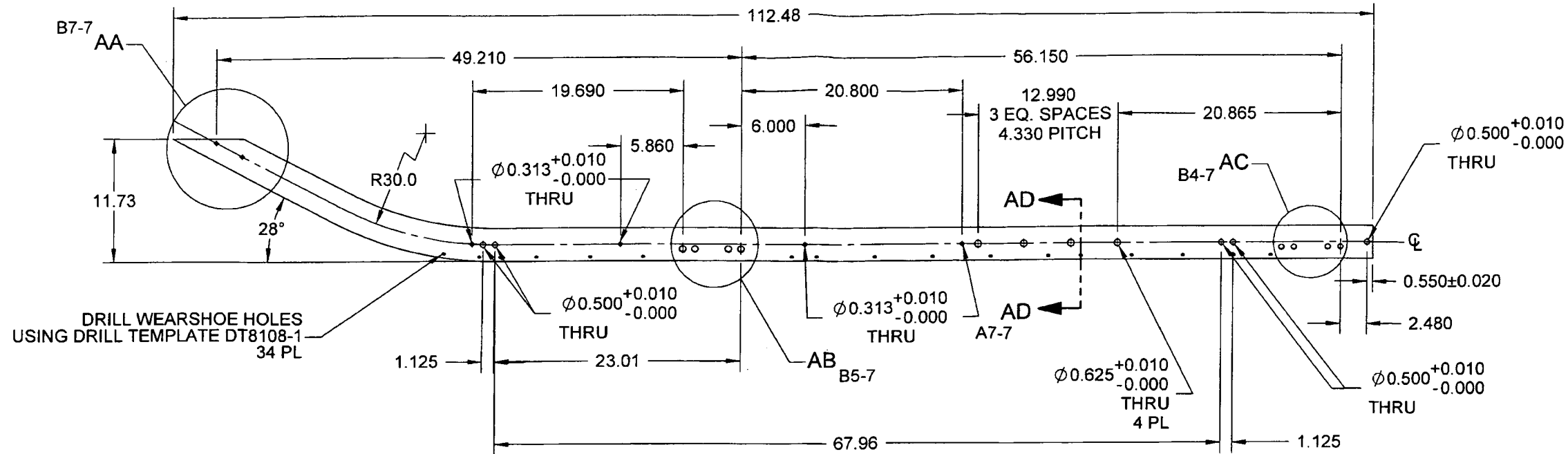


SECTION X-X
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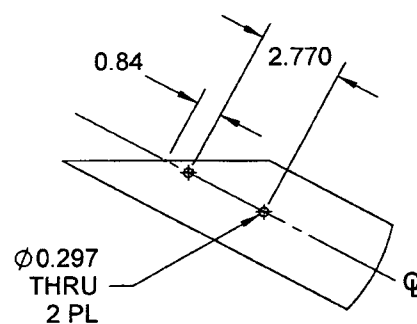
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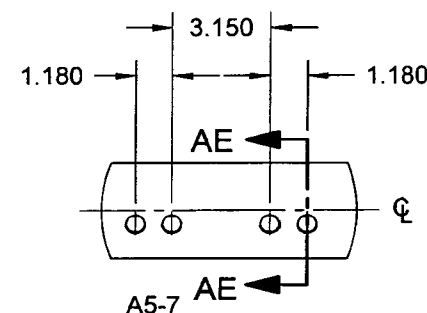
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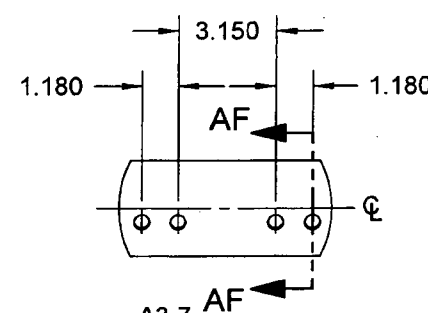
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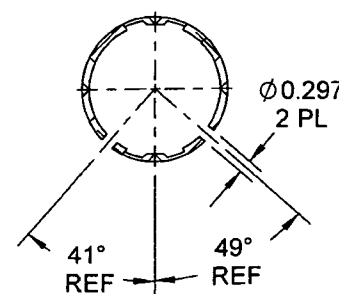
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D7-7



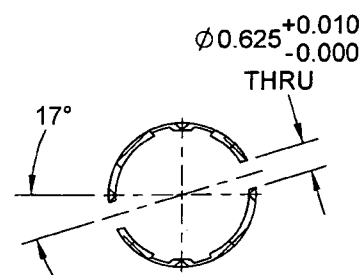
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C4-7
A5-7



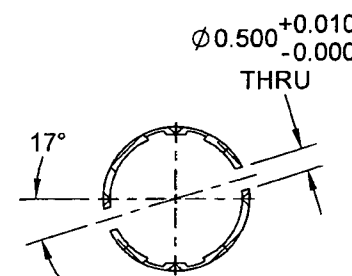
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D3-7
A3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



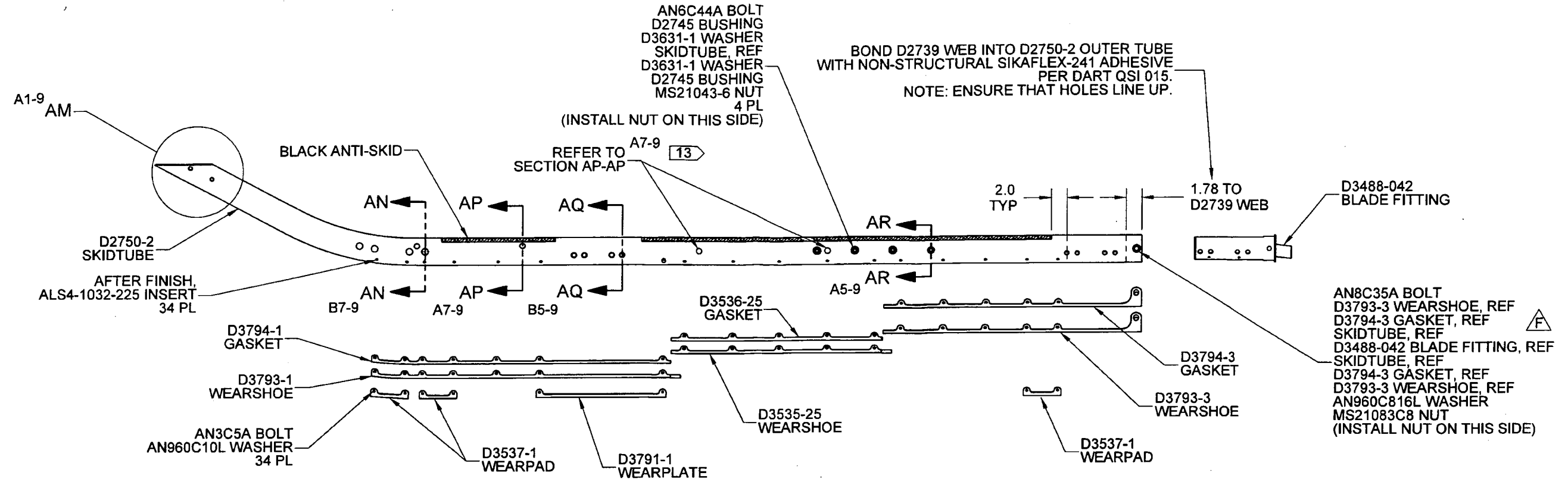
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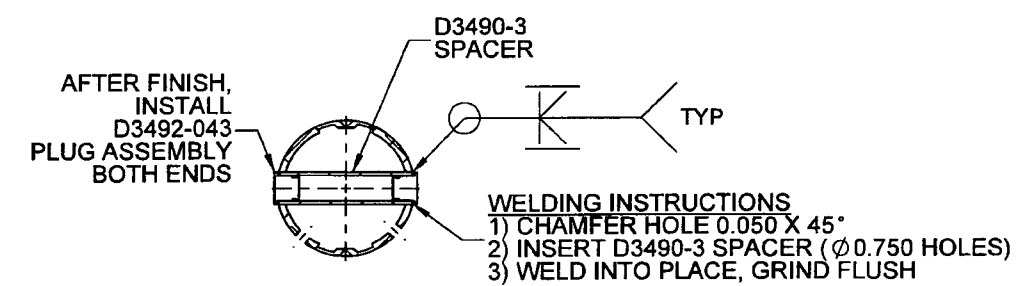
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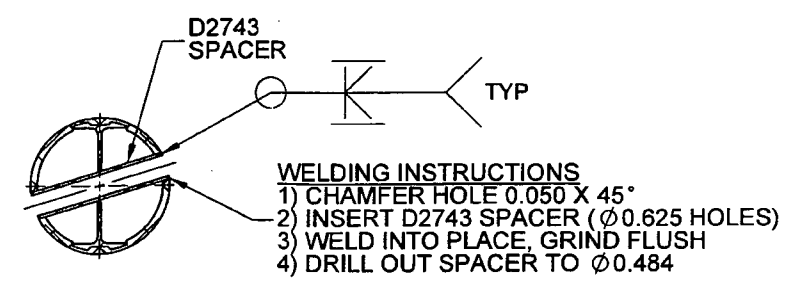
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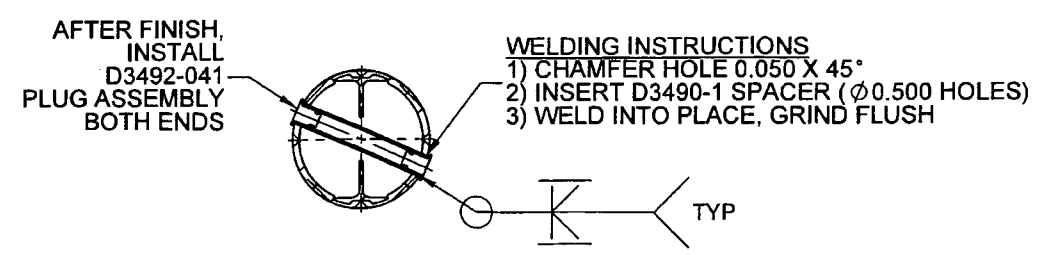
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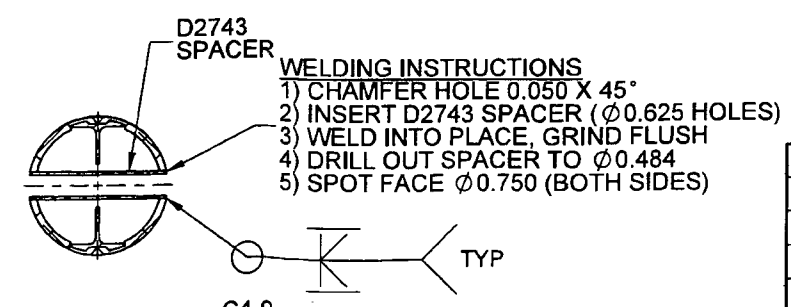
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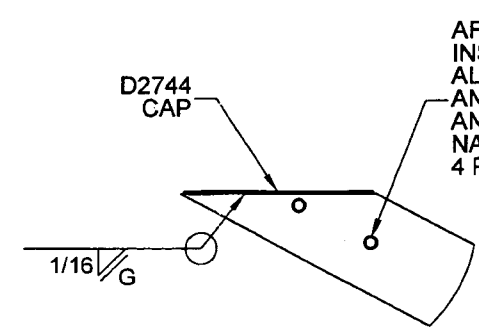
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SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



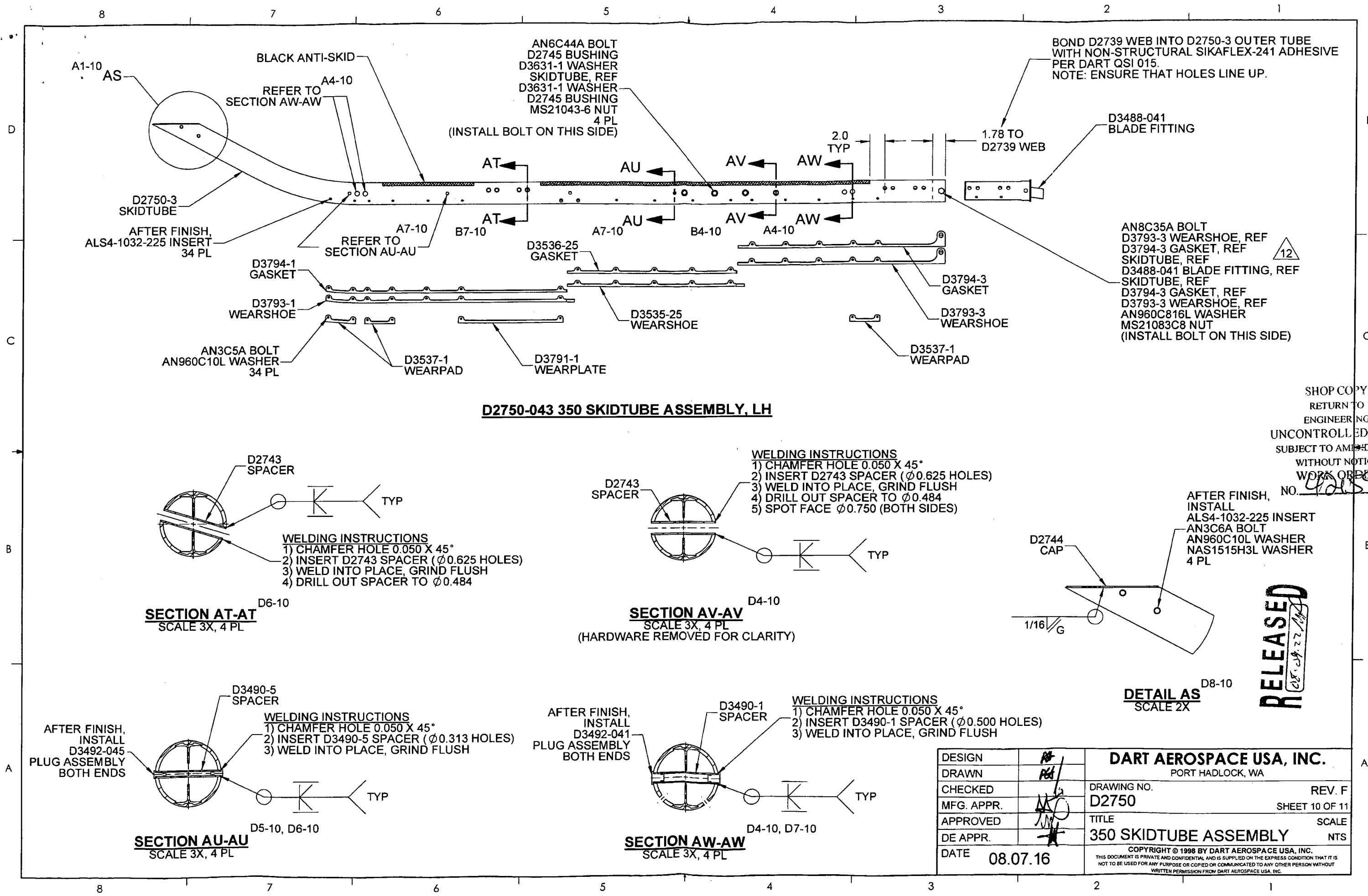
DETAIL AM
SCALE 2X

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

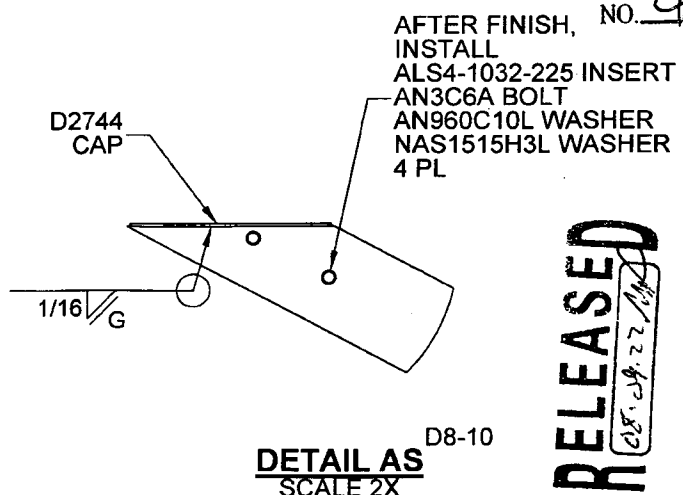
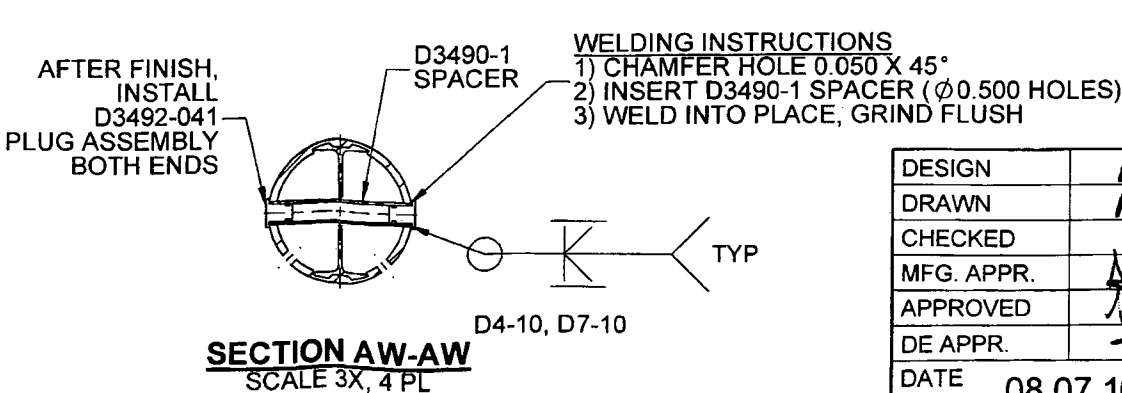
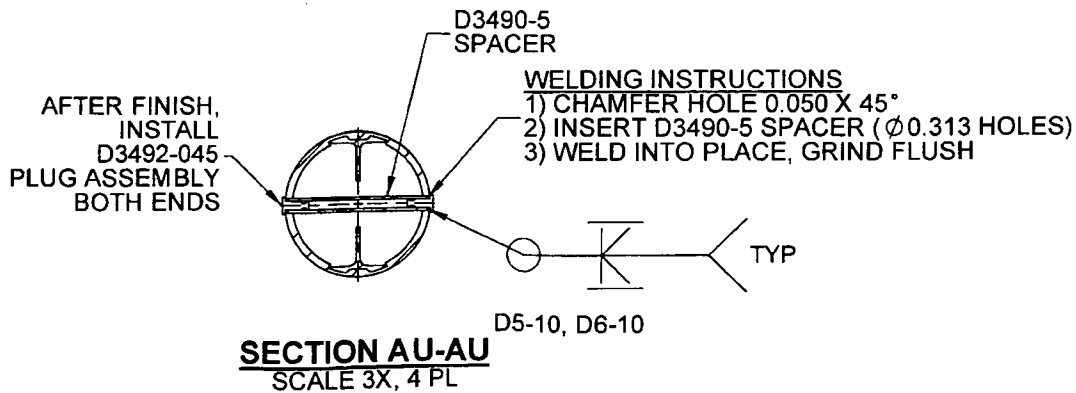
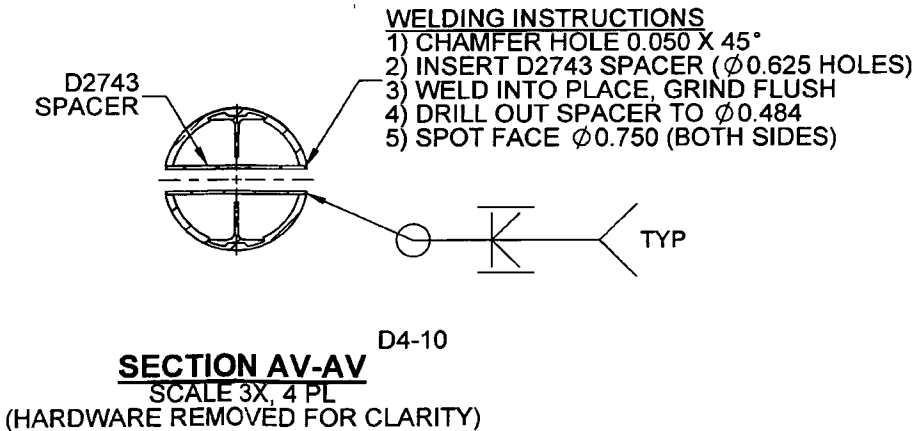
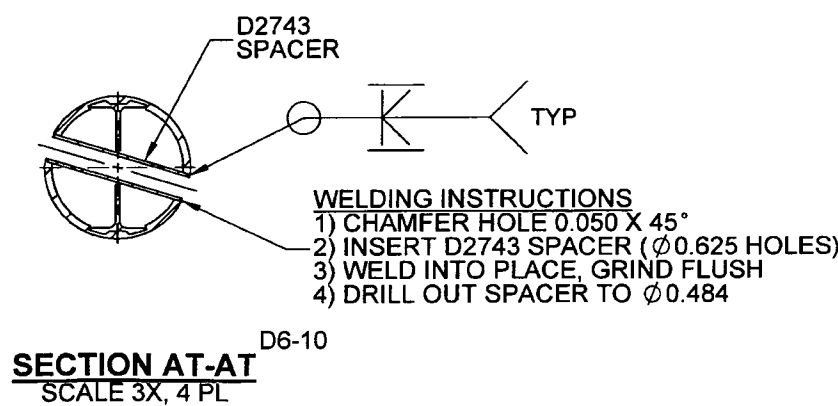
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